

Work Order ID 85125

June-04-12 8:20:50 AM

85125

Page 1

Item ID: D350-591-213

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop ***NS2***

Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3078	A
DSI 9472	A

100		0.00
-----	--	------

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

DAS 16 17/6/17 JB

MLJ 12-7-17 (5)

110		0.00
-----	--	------

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

5 0 Ae 12-06-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Page 3

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop ***NS2***

Start Date: 04/06/2012 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

Scalorhi

45

44

5

26

12-7-11

5

φ

pk

12 07 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop ***NS2***

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Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Large Fab

Large Fab

Memo

0.00

Large Fab

1- Rivet Leg Assembly as per Dwg D3078.
2-Bevel Aft end for welding
3-Inspect for foreign object as per QSI 024
4-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod 120854
5-Grind End Plate flush

5ØAe12.07.1212.07.13Ae 12.07.13

210

0.00

210

QC

Memo

0.00

Quality Control

DAS
16
2.8912/07/14

220

0.00

220

QC

Memo

0.00

Quality Control

DAS
16
2.8912/07/145
5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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June-04-12 8:20:50 AM

85125

Page 6

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

5

5

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260 QC Quality Control	Memo	0.00				5611	0	11	4/02/16
270	Pick Kit	0.00							
270 Packaging Packaging	Memo	0.00				5			12/07/17gB
280	QC4- 100% Inspect kits for completeness	0.00							
280 QC Quality Control	Memo	0.00				75			14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

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5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling:

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

290

0.00

290

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-213

Location: PPP Rev:

300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

(50)

12/7/17

12/7/18
UMF
12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

June-04-12 8:20:55 AM

Page 1

Work Order ID: 85125

85125

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM

IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D

10.03.17 incorporate seq 180 to 200 remove qc5 DD verified

by:JLM

IPP Rev:E

10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			110	Each	156.6100	0.5	2.5			

D2622-120C

**

Ac 12.06.26

Step Extrusion

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA

130.88

81507

4.88

83894

126

WA013

9.36

75781

2

77612

7.36

2.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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June-04-12 8:20:55 AM

Page 2

Work Order ID: 85125

85125

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3067-1

Manufactured No

130

Each

172.0000

1

5

D3067-1

**

End Plate

12.07.03

Location

Loc Qty

Loc Code

WA

139

78608

4

83855

60

84534

75

WA016

33

67582

2

68214

1

79607

1

83053

29

5

D3063-1

Manufactured No

130

Each

53.0000

1

5

D3063-1

**

Support

12.07.03

Location

Loc Qty

Loc Code

WA016

53

71886

53

MS20600-AD4W4

Purchased No

180

Each

3,464.000

16

80

MS20600-AD4W4

**

Rivets

12.07.12

Location

Loc Qty

Loc Code

321

1000

121652

1000

ST321

2324

121011

9

121340

315

121444

2000

WA018

140

118840

140

80

June-04-12 8:20:55 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

June-04-12 8:20:55 AM

Page 3

Work Order ID: 85125

85125

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step. Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3066-1	Manufactured	No	180	Each	71.0000	2	10
---------	--------------	----	-----	------	---------	---	----

D3066-1

Spacer

**

Ac 12.07.12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST176	71	
-------	----	--

<u>83854</u>	71	
--------------	----	--

D3065-041	Manufactured	No	180	Each	13.0000	1	
-----------	--------------	----	-----	------	---------	---	--

D3065-041

Step Leg Assembly Hi

**

(10)

383871 (5) Ac 12.07.12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	13	
----	----	--

66149	0	
-------	---	--

79336	1	
-------	---	--

80880	12	
-------	----	--

D3067-1	Manufactured	No	200	Each	172.0000	1	5
---------	--------------	----	-----	------	----------	---	---

D3067-1

End Plate

**

Ac 12.07.17

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	139	
----	-----	--

78608	4	
-------	---	--

<u>83855</u>	60	
--------------	----	--

<u>84534</u>	75	
--------------	----	--

WA016	33	
-------	----	--

67582	2	
-------	---	--

68214	1	
-------	---	--

79607	1	
-------	---	--

83053	29	
-------	----	--

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

June-04-12 8:20:55 AM

Page 4

Work Order ID: 85125

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125

D350-591-213

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN3-35A

Purchased

No

270

Each

116.0000

2

10

**

AN3-35A

Bolt

Location

Loc Qty

Loc Code

ST353

116

121652

116

121652

D2856-400

Manufactured

No

270

f

230.5445

0.6

3

**

D2856-400

Abrasion Strip

Location

Loc Qty

Loc Code

ST403

216

81875

216

81875

ST409

14.5445

63735

0.6696

68076

0.3149

71164

8.46

79551

5.1

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

AN4-11A

Purchased

No

270

Each

296.0000

2

10

**

AN4-11A

Bolt

Location

Loc Qty

Loc Code

ST356

296

118706

46

120731

100

121243

50

121708

100

121708

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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June-04-12 8:20:55 AM

Page 5

Work Order ID: 85125

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Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN960JD416

NAS1149D0463J

Purchased

No

270

Each

30 0000

12

60

**

121912

JB



AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

D2230-1

Manufactured

No

270

Each

20.0000

2

10

**

84135

JB



D2230-1

Lug

Location

Loc Qty

Loc Code

ST480

20

83273

20

MS21042L3

Purchased

No

270

Each

2,195.000

2

10

**

JB

12/07/12



MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

2195

117885

32

119017

952

119075

138

121349

221

121444

852

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 6

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Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN4-13A

Purchased

No

270

Each

1,261.000

20

AN4-13A

Bolt

Location

Loc Qty

Loc Code

ST357

1261

119449

33

120187

19

120422

2

120770

207

121652

1000

D2732

Manufactured

No

270

f

520.9153

1

D2732

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

520.915299

70987

20.915299

83560

500

cut qty of 4 at 1.00" as per dwg(D2732-030)

D2230-3

Manufactured

No

270

Each

90.0000

10

D2230-3

Lug

Location

Loc Qty

Loc Code

ST480

90

83261

90

AN960ID10

NAS1149D0363J

Purchased

No

270

Each

0.0000

20

AN960.ID10

Washer

June-04-12 8:20:56 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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June-04-12 8:20:56 AM

Page 7

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Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step. Short I H

85125

D350-591-213

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

270

Each

3.910.000



30

✓

MS21042L4

Nut

**

20



Location

Loc Qty

Loc Code

ST300

3910

119075

116

121011

537

121444

2957

121652

300

121444



AN4-16A

Purchased

No

270

Each

169.0000



20

✓

AN4-16A

Bolt

**

132122416 20

12/07/17

Location

Loc Qty

Loc Code

ST358

169

120498

14

121060

30

121444

75

121541

50

7x121444

June-04-12 8:20:56 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.01.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

85125
12/06/04
ML5

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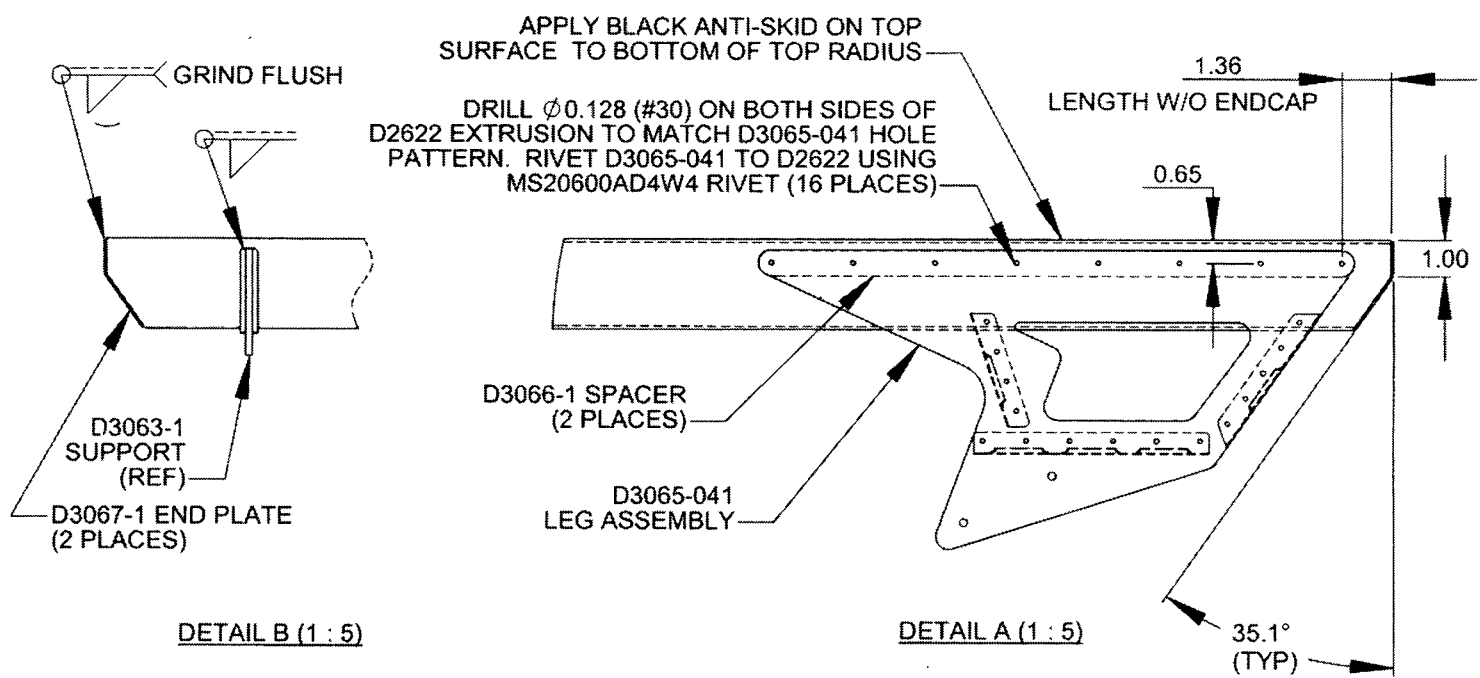
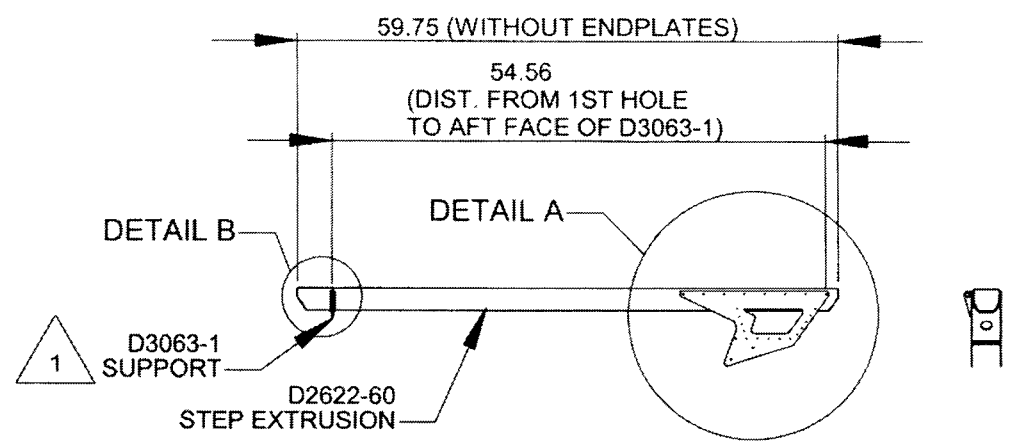
25125

DART



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CHECKED	✓	APPROVED	✓	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:



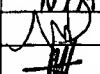
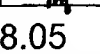
ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	NCA	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
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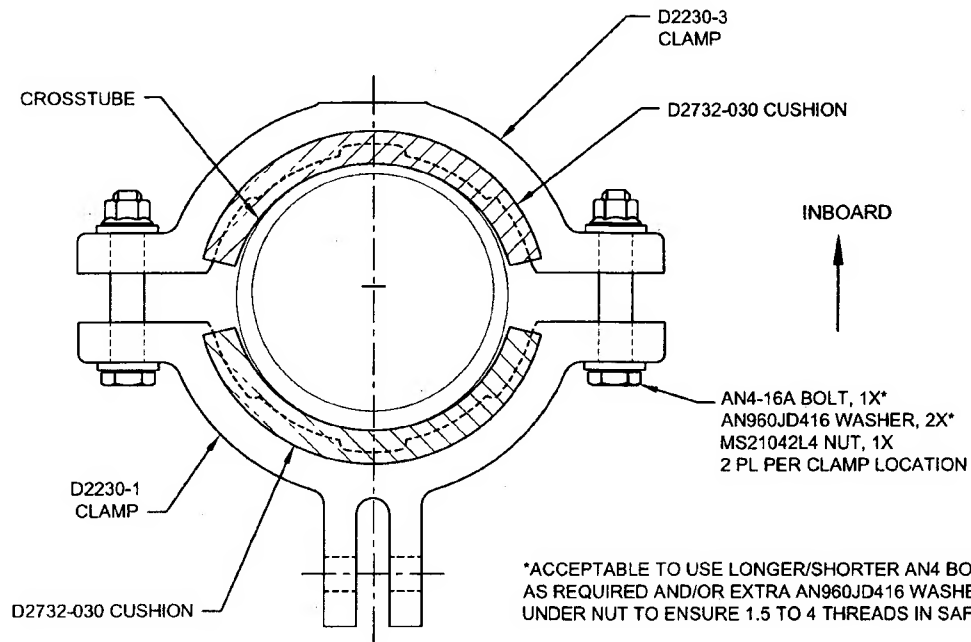




FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	GP	DART AEROSPACE LTD	
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CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
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05/25

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
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	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1	4	4	4	AN4-16A	BOLT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED
BY: <u>D. SHEPHERD (DE # 02)</u>
DATE: <u>09.08.05</u>
CERT. NO.: <u>SH92-6</u>
ISSUE NO.: <u>11</u>

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CHECKED	<u>UP</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>NCA</u>	DSI 9472	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
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